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D3562-042
Job Sheet 190377



Part No: D3562-042

Job Qty: 1 pcs

Part Name: Step Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/7/19

Job Tracking No:

Due Date: 3/5/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Notes: DWG REV G IPP Rev:A New Issue 06-11-09 JLM IPP rev B ECN 987 07.10.09 EC verified by: DD IPP Rev:C ECN1048 07-12-18 DD verified by: EC IPP Rev:D 08-07-28 add chemical conversion coat DD ver:EC IPP REV:E 13.06.03 PER DWG REV.F DD VERF:JLM IPP REV:F 16.06.23 AS PER DWG REV.G DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Steps - 1	1 pcs	3/5/19		0.00	1.42	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
110	QC 5	1 pcs	3/5/19		0.00	0.00	Large Fab - 9		SLN
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
120	Handfinish - 1-1 Chemical- B4B	1 pcs	3/5/19		0.00	0.25	QC 5 - 30		BEB 1902-14
							Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		

DAS
FEB 14 2019 68
9-89

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				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
130 QC 7	1 pcs	3/5/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 6	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
140 Small Fab - 2 - B4B	1 pcs	3/5/19	0.00 2.25	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	slm
				Small Fab - 3 - B4B	

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150 QC 5	1 pcs	3/5/19	0.00 0.00	Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	19-02-28
				QC 5 - 50	
				QC 5 - 30	
160 Large Fab - Steps - 2 - B4B	1 pcs	3/5/19	0.00 1.42	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	SLN
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
170 QC 10	1 pcs	3/5/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	SL
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
180 QC 5	1 pcs	3/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 42	
				QC 5 - 43	SL
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
190 Handfinish - 1-2- Chemical-B4B	1 pcs	3/5/19	0.00 0.25	Handfinish - 1 - 1 - B4B	PR 19/03/2019
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	

				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
200 Powdercoat - 1 White Gl(A)-B4B	1 pcs	3/5/19	0.00 0.34	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	BEB19-03-05
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
210 Handfinish - 3-1- WingWalk-B4B	1 pcs	3/5/19	0.00 0.25	Handfinish - 3 - 1 - B4B	AK 19-3-11
				Handfinish - 3 - 2 - B4B	
				Handfinish - 3 - 3 - B4B	
				Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
215 QC 3	1 pcs	3/5/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	DAS
				QC 3 - 68	MAR 12 2019 68
				QC 3 - 9	9-89
220 QC	1 pcs	3/5/19	0.00 0.00		
230 Packaging 3-1 - Stock - B4B	1	3/5/19	0.00 0.00	Packaging 3 - 1 - B4B	

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pcs				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	DAS
				Packaging 3 - 9 - B4B	36
				Packaging 3 - 10 - B4B	9-89
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				240 QC 21 - SA	1 pcs
QC 21 - SA - 70					
QC 21 - SA - 53					
Part Op 100 - (Fabricate per Drwg) 1-Cut D2622 extrusion as per Dwg D3562					
Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)					
120 - (Chemical Conversion Coat per QSI005 4.1)					
130 - (QC7-Inspect Chemical Conversion Coat)					
140 - (Small Fab) 1- Transfer drill Rivet holes as per dwg D3562.					
150 - (QC5- Inspect part completeness to step on W/O)					
160 - Weld per dwg A/R Aluminum rod Batch: _____) 1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.					
170 - (QC10- Inspect visual per QSI004- ground welds)					
180 - (QC5- Inspect part completeness to step on W/O)					
190 - Chemical Conversion Coat per QSI005 4.1)					
200 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum)START TIME: 10:00 TEMP: 320° FINISH: 10:30					
210 - (Wing Walk as per dwg QSI005 4.4 Batch _____)					
215 - QC3- Inspect Part Finish)					
230 - (Identify as per dwg & Stock Location: _____)					
240 - (QC21- Final Inspection - Work Order Release)					

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	1 pcs (1 ea)	100-Large Fab - Steps - 1	8104007
D2734	Step End Plate	2 pcs (2 ea)	140-Small Fab - 2 - B4B	8128761
D3560-042	Arm Weldment	1 pcs (1 ea)	140-Small Fab - 2 - B4B	8154650
D3560-044	Arm Weldment	1 pcs (1 ea)	140-Small Fab - 2 - B4B	8154661
MS20600-AD4W4	Rivet	32 Ea (32 ea)	140-Small Fab - 2 - B4B	8117999

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Steps - 1	D2622-120C	1	274	0
140-Small Fab - 2 - B4B	D2734	2	25	0
	D3560-042	1	2	0
	D3560-044	1	2	0
	MS20600-AD4W4	32	4,241	0

Part Specifications

Specifications could not be found.

8266

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Container No: S153018



Part: D3562-042

Job No: 190377

Serial No/Batch: S153018

Revision:

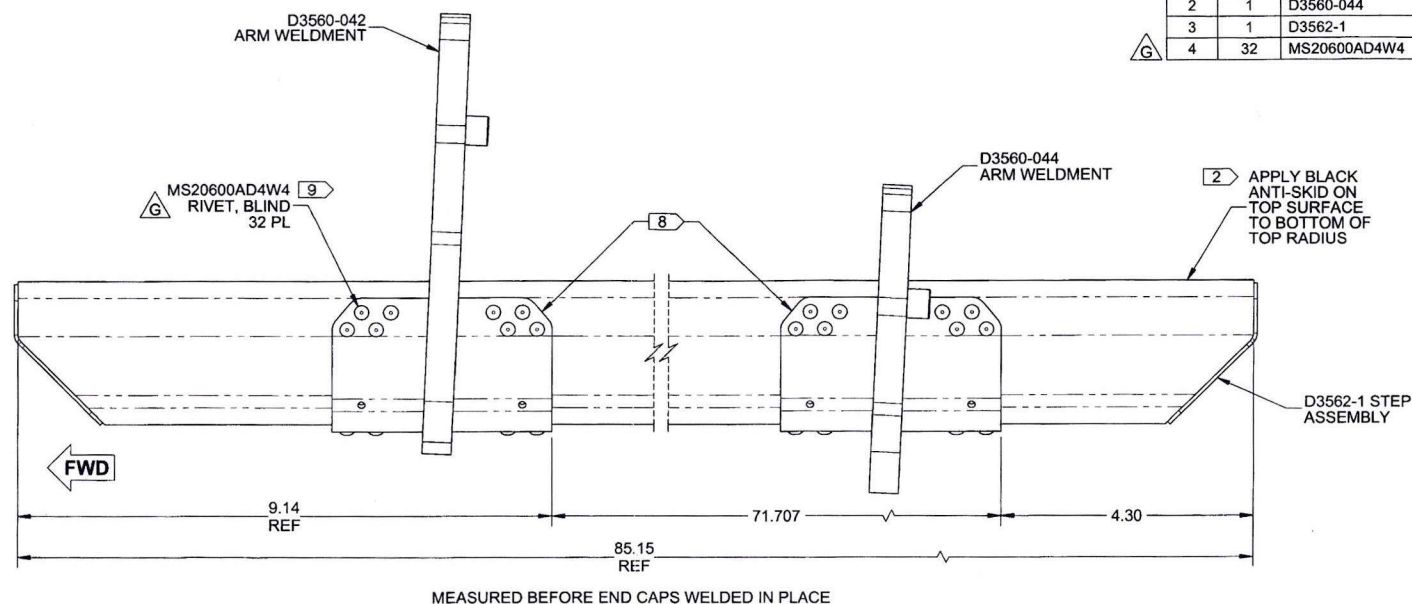
Inspector:

Exp Date:

Instructions: Various STC's

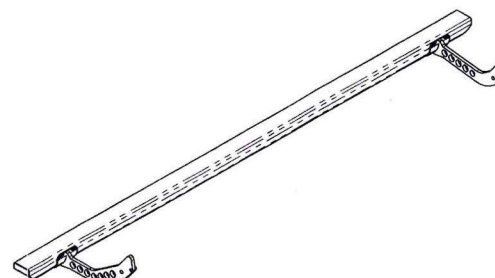
Date: 02/12/19

ITEM	QTY -042	P/N	DESCRIPTION
	X	D3562-042	RH STEP WELDMENT
1	1	D3560-042	ARM WELDMENT
2	1	D3560-044	ARM WELDMENT
3	1	D3562-1	STEP ASSEMBLY
4	32	MS20600AD4W4	RIVET, BLIND



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH:
 - i) POWDER COAT ASSEMBLY:
 - GLOSS WHITE (4.3.5.1) OR
 - GREY SANDEXT (4.3.5.6) OR
 - BLACK SANDEXT (4.3.5.7) OR
 - GREEN SANDEXT (4.3.5.8) PER DART QSI 005 4.3
 - ii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 8.80 lbs
- 8) INSTALL ARM WELDMENTS WITH A LAYER OF SCOTCH-WELD DP460 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH SCOTCH-WELD DP460. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 9) TRANSFER DRILL #30 DEBURR & TOUCH UP HOLES WITH CHEMICAL CONVERSION COAT BEFORE RIVETING



D3562-042 RH STEP ASSEMBLY

RELEASED

2016 JUN 22 4P

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	ML	DRAWING NO. D3562	REV. G
MFG. APPR.	DD	TITLE STEP ASSEMBLY	SHEET 2 OF 3
APPROVED	WM	SCALE	NTS
DE APPR.	DS	APPROVED	
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